

Work Order ID 74549

Tuesday, October 04, 2011 9:57:33 AM



Page 1

Item ID: D3405-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Lug Assembly

Start Date: 9/30/2011 Start Qty: 6.00



Cust Item ID:

Required Date: 10/14/2011 Req'd Qty: 6.00



Customer:

Reference:

Approvals: Process Plan: MLJ Date: 11/10/04 Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D3405

Rev B

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3405

Dwg Rev: BProg Rev: B

2-Debur if necessary

B11-10-29B11-10-25(B)

110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

B11-10-25

120

0.00



QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

5/10/28(+E)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 Brake NC	NC BRAKE	0.00				8			
Brake NC	Memo 1-Deburr 2-Form using DT8204 as per Dwg D3405 3- use DT9681 to check if correct forming	0.00							
140 QC	QC5- Inspect part completeness to step on W/O	0.00							
Quality Control	Memo	0.00							
150 Large Fab	Large Fab	0.00							
Large Fab	Memo Weld as per Dwg D3405 use DT8484 Identify as D3405-041	0.00							

SB 11/11/03

11 - 11 - 03 8

X7 JBL 11-11-17 PD →

M117659

W/O: <u>14549</u>		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3405-21 PAR #: _____ Fault Category: Loss PAB + inspecti NCR: Yes No DQA: h Date: 11/11/24
 Resolution: scrap Disposition: scrap QA: N/C Closed: ck Date: 11/11/24

NCR: <u>11-1006</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
<u>11/4/17</u>	<u># 142/150</u>	<u>Qty +1 lost Between weldin + inspecti</u> <u>RC 10A when handled</u> <u>Part.</u>	<u>S</u> <u>11/11/17</u> <u>Q57042</u>	<u>→ make as scrap</u> <u>unable to find</u>	<u>R</u> <u>11-11-16</u> <u>/</u>	<u>S</u> <u>11/11/17</u>	<u>S</u> <u>Q57042</u> <u>11/11/17</u>	<u>S</u> <u>11/11/17</u>

NOTE: Date & initial all entries

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Item Name: Lug Assembly

Start Date: 9/30/2011 Start Qty: 6.00



Cust Item ID:

Required Date: 10/14/2011 Req'd Qty: 6.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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160

QC9- Inspect visual per QSI004- Fusion Welds

0.00



QC

Memo

0.00

Quality Control

11.11.17 (7)

170

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

8/11/17

(7)

180

White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel

0.00



Powdercoat

Memo

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

8:45
400 OF
9:15

TX of M-11/11/18

M118439

W/O:		WORK ORDER CHANGES					
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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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190

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

7 BR 11-11-18

200

Identify as per dwg & Stock Location: ST 478 0.00



Packaging

Memo

0.00

Packaging

(7x) . SP 11-11-18

210

QC21- Final Inspection - Work Order Release 0.00



QC

Memo

0.00

Quality Control

11/11/18

11-11-18
①

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Picklist Print

Page 1

Tuesday, October 04, 2011 9:57:39 AM

Work Order ID: 74549

Parent Item: D3405-041

Parent Item Name: Lug Assembly



Start Date: 9/30/2011

Required Date: 10/14/2011

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP A 05.09.01 New issue KJ/JLM
IPP B 09.01.28 rev.B drawing EC verified by:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D3404-1		Manufactured	No			100	Each	20.0000	1	6			
 GHW Lug				74551 X8 7						12L 11-11-16			

Location

Loc Qty

Loc Code

WA

7

70664

7

WA030

13

72326

13

M304S11GA

Purchased

No

150

sf

143.9000

0.154

0.972632



304/316 0.125 Sheet



B110-10-25

Location

Loc Qty

Loc Code

MAT020

143.9

117494

15.9

119006

64

119048

64

117494

8

W/O:		WORK ORDER CHANGES					
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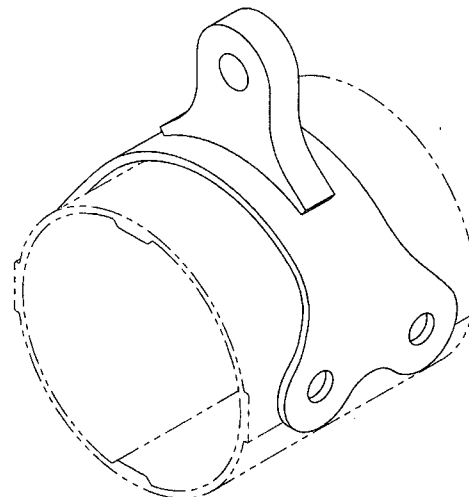
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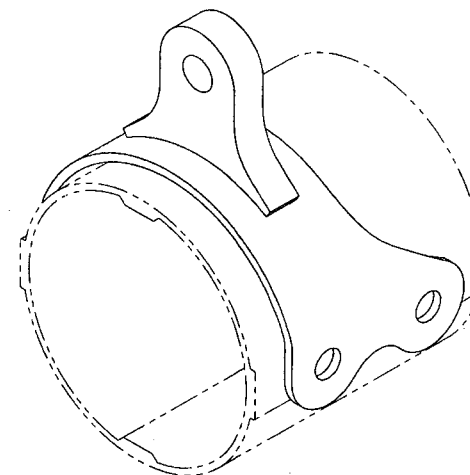
ITEM No.	QTY. -041	QTY. -043	PART NUMBER	DESCRIPTION
1	X		D3405-041	LUG ASSEMBLY
2		X	D3405-043	LUG ASSEMBLY
11	1	1	D3404-1	GHW LUG
12	1		D3405-1	GHW BRACKET
13		1	D3405-3	GHW BRACKET

△B

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 74549 M.C. J.
11/10/04



D3405-041 LUG ASSEMBLY
(SKID TUBE SECTION SHOWN
FOR REF ONLY)



D3405-043 LUG ASSEMBLY
(SKID TUBE SECTION SHOWN
FOR REF ONLY)

RELEASED
08/12/18

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT ASSEMBLY WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3405-041" USING FINE POINT PERMANENT INK MARKER
IDENTIFY WITH DART P/N "D3405-043" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: -041, 0.85 lbs
-043, 0.87 lbs

B	DRAWING REDRAWN IN SOLIDWORKS WITH CURRENT STANDARDS AND TRANSFERRED TO "B" SIZE BORDER. FLAT PATTERNS FOR -1 & -3 INCREASED IN LENGTH TO PREVENT FOULING AT INSTL (SEE PAR198). SHEETS 3 & 4 ZONE A6 4.120 DIM WAS 4.100.	AJS	08.09.19
A	NEW ISSUE	PH	05.03.08
REV.	DESCRIPTION	BY	DATE
DESIGN	PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D3405 REV. B SHEET 1 OF 4 TITLE GHW LUG ASSEMBLY SCALE NTS <small>COPYRIGHT © 2005 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	
DRAWN	AJS		
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	08.09.19		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

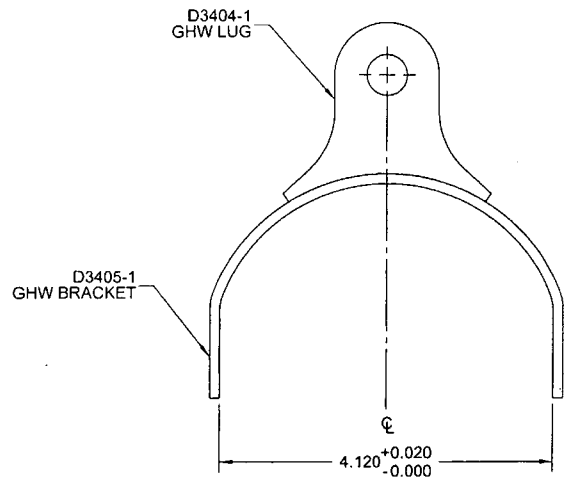
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

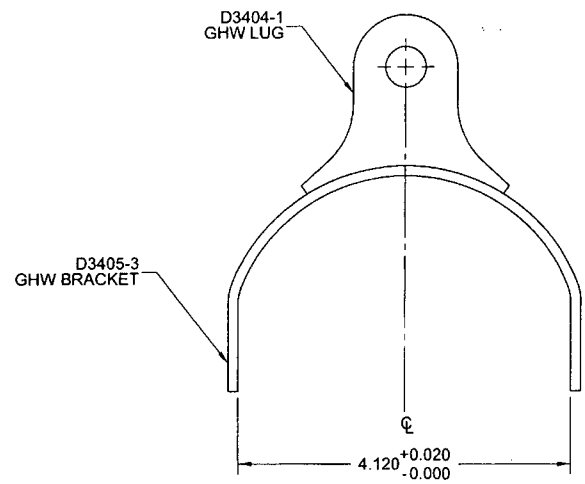
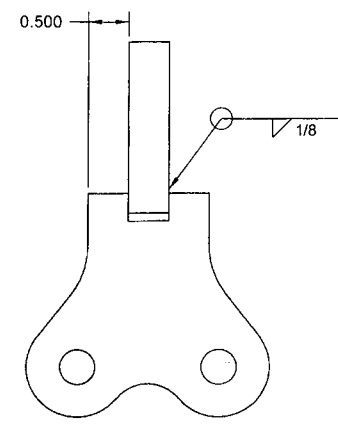
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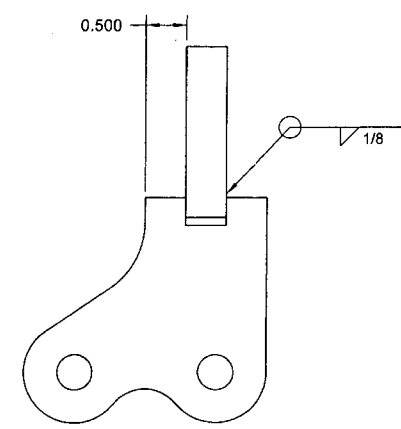
74549



D3405-041 LUG ASSEMBLY



D3405-043 LUG ASSEMBLY



RELEASED
06/12/18

DESIGN	PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3405	SHEET 2 OF 4
APPROVED		TITLE	SCALE
DE APPR.		GHW LUG ASSEMBLY	NTS
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

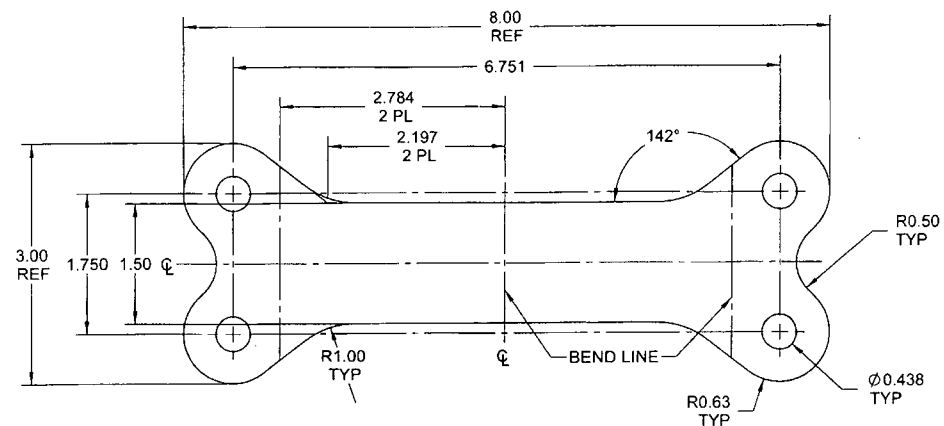
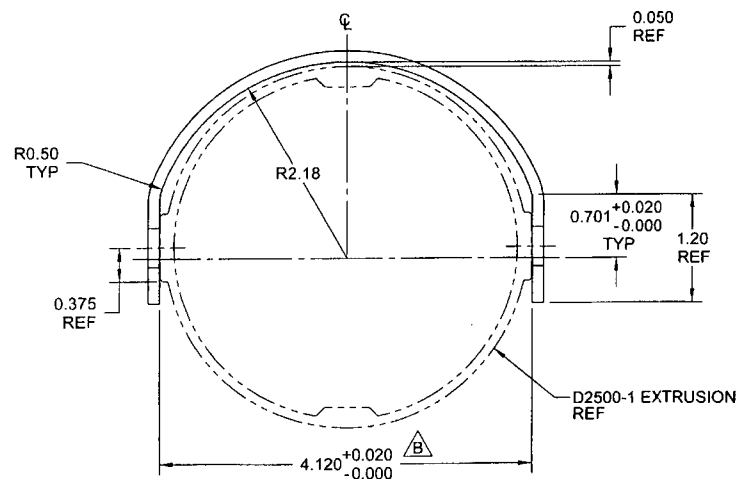
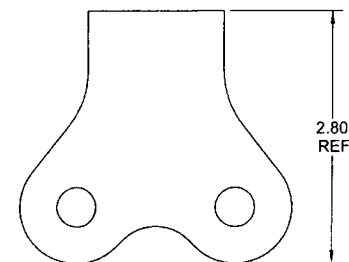
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NOTE: Date & initial all entries

74549

**D3405-1F GHW BRACKET FLAT PATTERN****D3405-1 GHW BRACKET**
(MAKE FROM D3405-1F)

SIDE VIEW FOR REF ONLY

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 11 GAUGE (0.125 THICK)
PER MIL-S-5059 (ANNEALED) 2B FINISH OR AMS 5513/5524
REF. DART SPEC. M304S11GA
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: N/A

RELEASED
07/08/12

DESIGN	PH	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3405	SHEET 3 OF 4
APPROVED		TITLE	SCALE
DE APPR.		GHW LUG ASSEMBLY	NTS
DATE	08.09.19	<small>COPYRIGHT © 2005 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CO-ORDINATION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

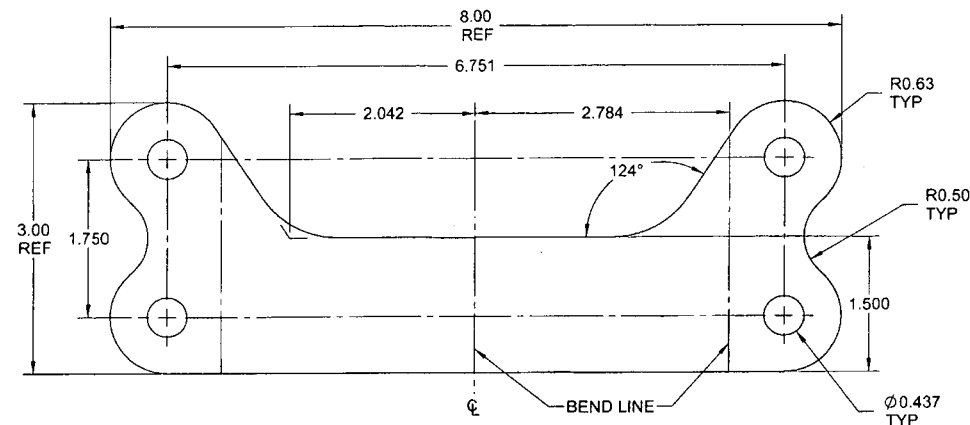
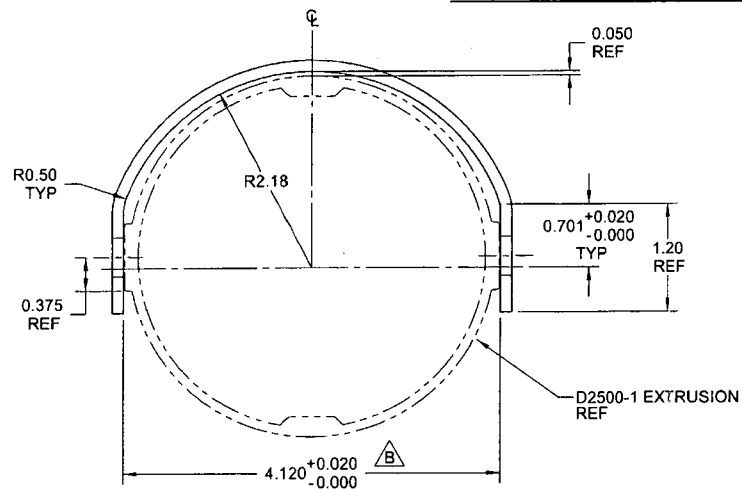
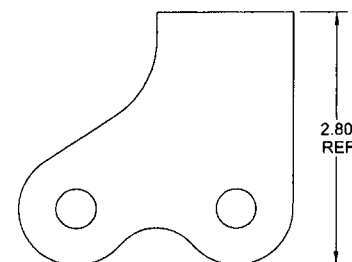
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74549

**D3405-3F GHW BRACKET FLAT PATTERN****D3405-3 GHW BRACKET**
(MAKE FROM D3405-3F)

SIDE VIEW FOR REF ONLY

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 11 GAUGE (0.125 THICK)
PER MIL-S-5059 (ANNEALED) 2B FINISH OR AMS 5513/5524
REF. DART SPEC. M304S11GA
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: N/A

RELEASED
06/12/18

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